

# Work Order ID 83765

**\*83765\***

Page 1

April-25-12 10:10:31 AM

Item ID: D3898-1 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Floor Protector (206L)  
 Start Date: 25/04/2012 Start Qty: 2.00 **\*2\*** Cust Item ID:  
 Required Date: 09/05/2012 Req'd Qty: 2.00 **\*2\*** Customer:  
 Reference:

Approvals: Process Plan: MLJ Date: 12/04/25 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3898	Rev A

100		0.00							
<b>*100*</b>									
HandThermo	Memo	0.00				<u>2</u>			<u>B 12/04/27</u>
Hand Finishing Thermoforming	1-Cut Sheet to required Blank size								

105		0.00							
<b>*105*</b>									
HandThermo	Memo	0.00							
Hand Finishing Thermoforming	Dry Sheet as per QSI022 POLYCARBONATE								
	Temp: <u>240</u>								
	Time IN: <u>4:45</u>								
	Time OUT: <u>7:00</u>								

(2)

B 12/04/27  
8375-4

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
110 <b>*110*</b> Thermoform Thermoforming Machine	<b>Memo</b> 1-Machine Set-Up 2-Pre-heat Tool to required temp. 3-Thermoform as per Dwg and Folio #FTA0xxusing tool DT9501 Dwg Rev: <u>  A  </u> Folio Rev: <u>  X  </u>	0.00  0.00				(2)			B 12/04/27
120 <b>*120*</b> QC Quality Control	QC2- Inspect parts off machine FAI/FAIB  <b>Memo</b> Visually inspect part for proper formation and texture	0.00  0.00				(2)			B 12/04/27
130 <b>*130*</b> QC Quality Control	QC8- Inspect parts - second check  <b>Memo</b>	0.00  0.00							12/04/27

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NOTE: Date & initial all entries



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**NOTE:** Date & initial all entries

April-25-12 10:10:31 AM

**Item ID:** D3898-1

**Accept**

**\*N900040100\***

Setup Start \*NS1\*

Revision ID:

**Item Name:** Floor Protector (206L)

Stop \*NS2\*

**Start Date:** 25/04/2012    **Start Qty:** 2.00

\*2\*

**Cust Item ID:**

**Required Date:** 09/05/2012      **Req'd Qty:** 2.00

\*2\*

**Customer:**

**Reference:**

**Approvals:**      **Process Plan:** \_\_\_\_\_ **Date:** \_\_\_\_\_ **Tooling:** \_\_\_\_\_ **Date:** \_\_\_\_\_

Run Start \*NR1\*

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop \*NR2\*

Sequence ID/  
Work Center ID

### Operation Description

### Set Up/ Run Hours

**Tool ID**

Tool #

**Plan  
Code**

**Accept  
Qty**

## Reject Qty

Reject  
Number

**Insp.**  
**Stamp**

170

Identify as per dwg & Stock Location:\_\_\_\_\_

0.00

**\*170\***

### Packaging

## Memo

0.00

## Packaging

180

QC21- Final Inspection - Work Order Release

0.00

**\*180\***

QC

## Memo

0.00

## Quality Control

12/5/10 JJ

MC 12-05-15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries



# Picklist Print

April-25-12 10:10:36 AM

Page 1

Work Order ID: 83765

\*83765\*

Parent Item: D3898-1

\*D3898-1\*

Parent Item Name: Floor Protector (206L)

Start Date: 25/04/2012

Required Date: 09/05/2012

Start Qty: 2.00

Required Qty: 2.00

Comments:

IPP Rev.A New Issue 09/02/06 DL

IPP RevB

Add Step 105 Dry Material 10/04/21 DL

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MLEXS.118-90318-08		Purchased	No			100	sf	1,383.746	10.6	22.31579			

\*MI FXS 118-90318-08\*

Lexan Sheet

\*\*

Location

therm

113127

Loc Qty

1383.746941

1383.74694

Loc Code

22.32 sq ft.

12/04/27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

DART AEROSPACE LTD		Work Order:	83765
Description: Floor Protector		Part Number:	D3898-1
Inspection Dwg: D3898	Rev: A	Page 1 of 1	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

#### THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than "	✓			
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

Measured by: BB Date: 12/04/27

#### TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.50	Min	.575	✓		TH-05	
1.00	Min	1.060	✓		TH-05	
5.6	+0.2/-0.0	5.62	✓		TH-05	
0.080	Min	.095	✓		TH-DT	
0.050	Min	.057	✓		DL-02	

Measured by: BB Date: 12/05/11

Audited by: Dh Date: 12/05/11

Prototype Approval: N/A Date: N/A

Rev	Date	Change	Revised by	Approved
A	09.09.15	New Issue	KJ	<u>BB</u>

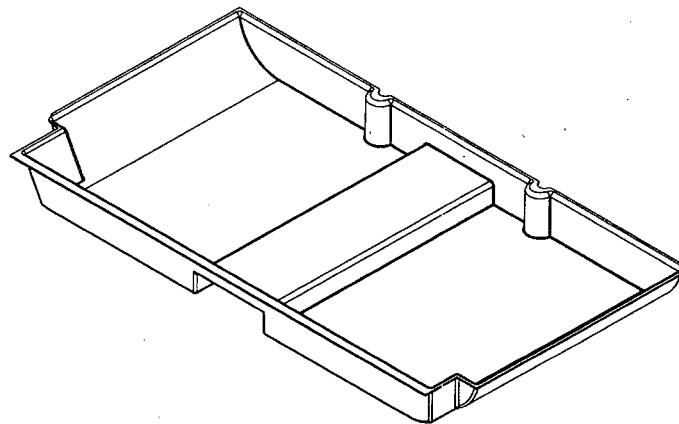
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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**NOTE:** Date & initial all entries



**D3898-1 FLOOR PROTECTOR (206L)**

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COI  
SUBJECT TO AMENDMEN  
WITHOUT NOTICE  
WORK ORDER  
NO. B3765 MLJ

12/04/25

**RELEASED**  
07/06/23 MLJ

**NOTES:**

- 1) MATERIAL: LEXAN 90318 (PROTECT-A-GLAZE), 0.118 THICK, 112-CLEAR (MLEXS.118-90318-08)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3898-1" USING VIBRATING STYLUS
- 7) WEIGHT: 5.0 lbs
- 8) TOOLING: THERMOFORM PER MOLD DT9501 PER DART QSI 022. TRIM PER MOLD
- 9) MINIMUM THICKNESS: 0.050" EXCEPT AS SHOWN

A	NEW ISSUE	PH	09.02.27
REV.	DESCRIPTION	BY	DATE
DESIGN	PH	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	PH		
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3898	SHEET 1 OF 2
APPROVED		TITLE	SCALE
DE APPR.		FLOOR PROTECTOR (206L)	NTS
DATE	09.02.27	<small>COPYRIGHT © 2009 BY DART AEROSPACE LTD  THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS  NOT TO BE USED FOR ANY PURPOSE OR DISCLOSED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT  WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

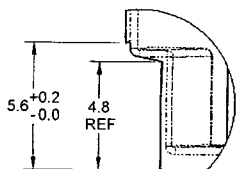
W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

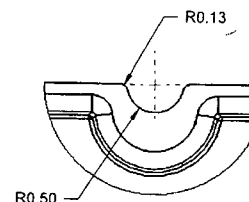
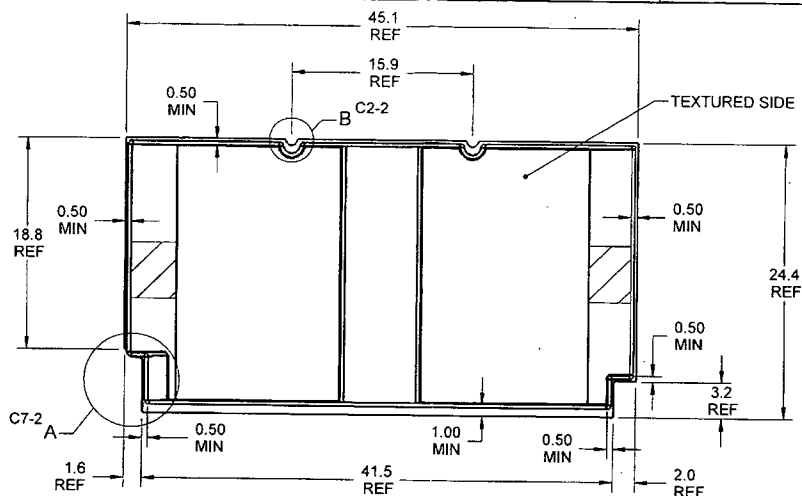
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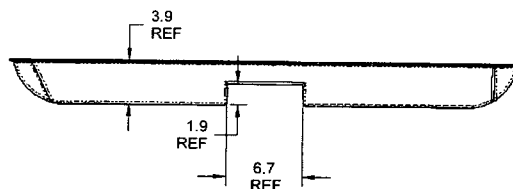
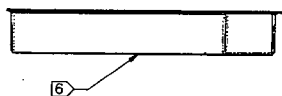
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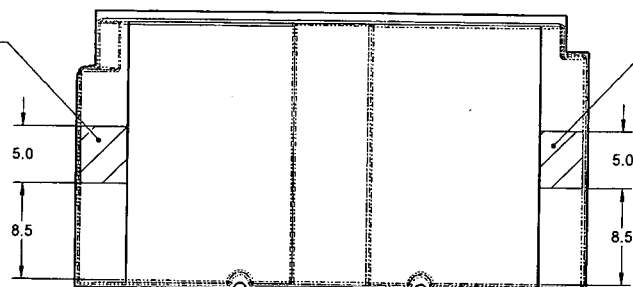
**DETAIL A** C6-2  
SCALE 2X



**DETAIL B** D5-2  
SCALE 5X  
2 PL



MIN THICKNESS  
0.080  
(SHADED REGION)



MIN THICKNESS  
0.080  
(SHADED REGION)

**RELEASED**  
09/06/08 JWF

**D3898-1 FLOOR PROTECTOR (206L)**

DESIGN	PH	<b>DART AEROSPACE LTD</b>	
DRAWN	PH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	SP	DRAWING NO.	REV. A
MFG. APPR.	SP	D3898	SHEET 2 OF 2
APPROVED	SP	TITLE	SCALE
DE APPR.	SP	FLOOR PROTECTOR (206L)	NTS
DATE	09.02.27	<small>COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

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